

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 5907 (1970): Socket Reamers with Morse Taper Shanks [PGD
32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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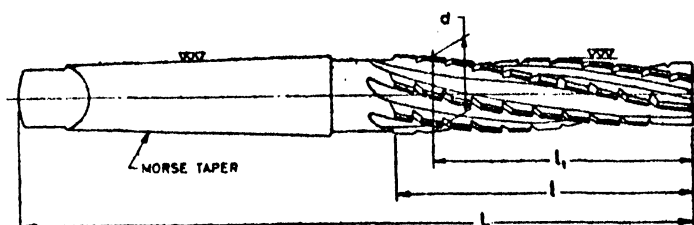
**AMENDMENT NO. 3 DECEMBER 1996
TO
IS 5907 : 1970 SPECIFICATION FOR SOCKET
REAMERS WITH MORSE TAPER SHANKS**
(*Page 2, clause 5.2*) — Substitute 'IS 5443 : 1994' for 'IS 5443 : 1969'.



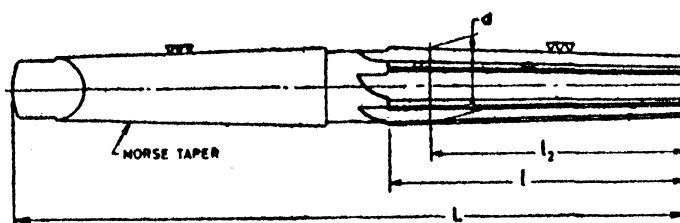
Indian Standard
**SPECIFICATION FOR
SOCKET REAMERS WITH MORSE TAPER SHANKS**

1. Scope — Dimensions and requirements for socket reamers with morse taper shanks.

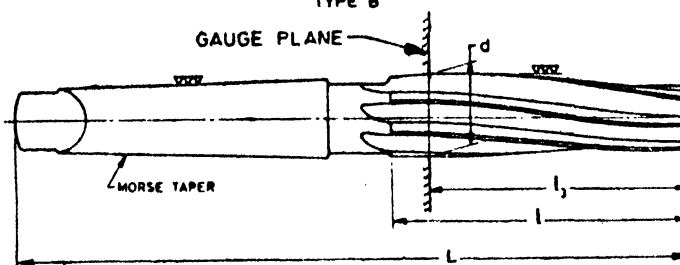
2. Dimensions



TYPE A



TYPE B



TYPE C

All dimensions in millimetres.

Designating Size	Gauge Diameter d	l_1	l_2	l_3	l	L	Taper on Diameter	Morse Taper Shank
Metric 4	4.000	20	28	22	30	106	1 : 20.000 = 0.05	1
Metric 6	6.000	36	34	30	40	116	1 : 20.000 = 0.05	1
Morse 0	9.045	56	52	48	61	137	1 : 19.212 = 0.052 05	1
Morse 1	12.065	58	54	50	66	142	1 : 20.047 = 0.049 88	1
Morse 2	17.780	69	65	61	79	173	1 : 20.020 = 0.049 95	2
Morse 3	23.825	84	80	76	96	212	1 : 19.922 = 0.050 20	3
Morse 4	31.267	107	103	97	119	263	1 : 19.254 = 0.051 94	3
Morse 5	44.399	134	130	124	150	331	1 : 19.002 = 0.052 63	5
Morse 6	63.348	186	182	176	208	389	1 : 19.180 = 0.052 14	5

Note — The figures are indicative of dimensions only and do not specify design features.

3. Designation — A socket of reamer Type A having designating size Morse 5 and made from carbon steel (CS) shall be designated as:

Reamer A Morse 5 IS : 5907 CS.

3.1 When required in a set of three reamers, comprising one each of Types A, B and C, the letter 'A' shall be omitted in the designation above.

Adopted 4 December 1970

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4. Tolerances on Overall Length L and Cutting Edge Length l

All dimensions in millimetres.

Length		Tolerance
Over	Up to and including	
0	6	± 1.5
6	18	± 3.0
18	50	± 5.0
50	—	± 6.5

5. General Requirements

5.1 Flutes unless specified otherwise shall be as follows:

- a) Type A — Right hand helical flutes for right-hand cutting
- b) Type B — Parallel flutes for right-hand cutting
- c) Type C — Left hand helical flutes for right-hand cutting

5.2 Other requirements according to IS : 5443-1969 'Technical supply conditions for reamers'.

EXPLANATORY NOTE

In order to bring in line with the work done at ISO level, the Small Tools Sectional Committee decided to revise IS : 1836-1961 'Reamers' and to split it up into a series of standards. This standard covers the dimensional requirements for socket reamers with morse taper shanks. The technical supply conditions for reamers and the dimensional requirements of various other reamers are covered in separate standards.